



Dart Aerospace Ltd.
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RB6891195-13
Job Sheet 178231



004694

Part No: RB6891195-13

Job Qty: 2 ea

Part Name: Spline Assy.



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 5/29/18

Job Tracking No:

Due Date: 7/3/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RB6891195 REV 1 IPP REV A 18.05.29 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	7/3/18	7/3/18	0.00	0.00	Start Up Small Fab-2		MCC
110	Small Fab	2 pcs	7/3/18	7/3/18	0.00	2.00	Small Fab-3		MCC
115	QC	2 pcs	7/3/18	7/3/18	0.00	0.00	QC5		18-7-26
120	Mill Conv	2 pcs	7/3/18	7/3/18	0.00	0.67	Mill Conv 2		18-7-26
130	QC	2 pcs	7/3/18	7/3/18	0.00	0.00	QC2 Machining-2		18-7-26
140	QC	2 pcs	7/3/18	7/3/18	0.00	0.00	QC8 Machining-2		18-7-26
160	Packaging	2 pcs	7/3/18	7/3/18	0.00	0.00	Packaging3-1		18-7-26
170	QC21-SA	2 Ea	7/3/18	7/3/18	0.00	0.00	QC21		DAS 21 9-88 JUL 27 2018

Part Op 110 - 1- Assemble as per DWG.
Descriptions: 120 -- Drill hole as per dwg

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB6891195-1	Locator	2 Ea (1 ea)	90-Start up Operation	5094664 A
98381A470	Dowel Pin	2 Ea (1 ea)	110-Small Fab	5094664-36
RB6891195-11	Guide	2 Ea (1 ea)	110-Small Fab	5093036
RB6891195-2	Spline	2 Ea (1 ea)	110-Small Fab	5094655 A
S-50	Spring Plunger	2 Ea (1 ea)	110-Small Fab	3084081

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RB6891195-1	2	6	0
110-Small Fab	98381A470	2	100	0
	RB6891195-11	2	8	0
	RB6891195-2	2	6	0
	S-50	2	10	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____

Part No. _____

NCR No. _____

Date: _____

Des _____

NON-CONFORMANCE / UPDATE

Work Order update only



AGAINST DEPARTMENT/PROCESS

Water Jet	☐	Engineering	☐
Prod. Eng. Coord.	☐	Quality	☐
Re/Packaging	☐	Other	☐
Supplier	☐		☐

MRB (QS042) Approval

Completed By

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval

DART AEROSPACE
Container No: S096726
Part: RB6891195-13
Job No: 178231
Serial No/Batch: S096726
Revision: 1
Inspector:
Exp Date:
Instructions:

Date: 07/26/18

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FAULT

Positioned Wrong	☐
Outside Dimensions	☐
Over/Under tolerance	☐
Part Incorrect	☐
Part Lost/Missing	☐
Part Moved	☐
Drawing	☐
Finish	☐
Misread	☐
Turning Sequence	☐

Power Loss/Surge	☐
Folio/Program	☐
Grain	☐
Weld	☐
Wrong Stock Pulled	☐
Out of Sequence	☐
Off-set	☐
Mislabeled	☐
Fit/Function	☐
Misaligned/off center	☐

Temperature/Cure	☐
Set-up	☐
BOM/Route	☐
Broken/Damage/Defect	☐
Inspection Incomplete/Unqualified	☐
Contamination	☐
Countersink	☐
Cut Too Short	☐
Instructions Incomplete/Unclear	☐
Drill Holes	☐

Pressure/Forced	☐
Bending	☐
Centre Not Concentric	☐
Cracks	☐
Crimp/Kink/Ripple/Wave	☐
Cuffs	☐
Crushing	☐
Heat Treat	☐
Wave/Twist in Tube	☐
Marks/Chatter	☐

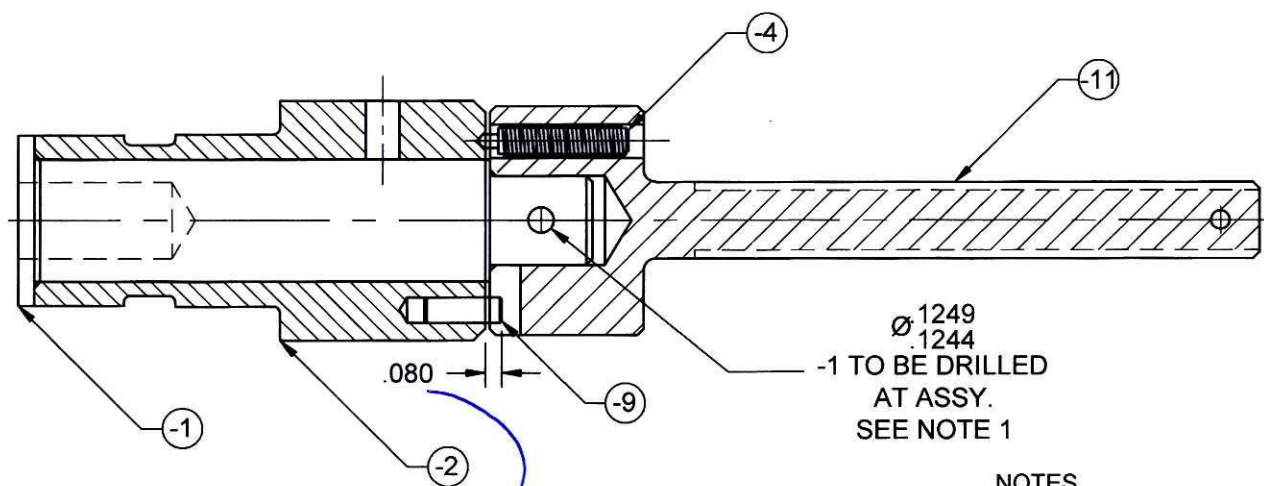
Root Cause

Environment	☐
Design	☐
Doc/Data	☐
Equip/Tooling	☐
Handling/Pre	☐
Material	☐
Internal Transport	☐
Tribal Knowledge	☐
LOA	☐
Substation	☐
Past Expiry Date	☐
Misidentified	☐
No Re-verification	☐
Operator	☐
Offset/Setup	☐
Supplier	☐
Training	☐
Use for Testing	☐
Poor Information	☐
Rushing	☐
Product Improvement	☐
Process Improvement	☐
Manufacturing Process	☐
Past Due	☐

OTHER :

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
B	REDRAWN FROM TATTERED ORIGINAL PER D.W.	9/16/11	RJC
1	CH'D -13 HOLE FROM Ø.1250-.1245 P.F. -10 AT ASSY. PER G.E.	5/29/12	RJC



NOTES

- ENSURE -1 & -2 SPLINES ARE ALIGNED AND -4 SPRING PLUNGER IS ALIGNED WITH COUNTERSINK PRIOR TO DRILLING HOLE.

MAX 0.103"
mfg JULY 26/18

RED BARN MACHINE	
TITLE PULLER - COMPRESSOR ROTOR SPLINED ADAPTER	
DWG NO. RB6891195-13	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 XX ± .01 X ± .1	
METRIC REF. XXmm ± .1mm FRACTIONS ± 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 7/8/11
DRAWN BY CLOUGH APPROVED D. Weid HEAT TREAT FINISH BLACK OXIDE SPEC USED ON MODEL ROLLS-ROYCE 250 SERIES	
SHEET 11 of 11	